

Work Order ID 71146

Thursday, June 23, 2011 12:35:30 PM



Page 1

Item ID: D3808-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Rail Assembly

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00

Customer: \

Reference:

Approvals: Process Plan: MF Date: 11-06-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3808

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install Plunger as per Dwg D3808.112-Install helicoils x5 as per Dwg D3808.

6/24/07/12 (1)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12

(2)

120

Identify as per dwg & Stock Location: 262

0.00



Packaging

Memo

0.00

Packaging

6/12/12 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13 *[Signature]*
MF 11-07-12

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:35:26 PM

Page 1

Work Order ID: 71146

Parent Item: D3808-041

Parent Item Name: Seat Rail Assembly



Start Date: 6/23/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3808-1 Seat Rail		Manufactured	No			100	Each	1.0000	1	1		6/11/07/12	
<div> <div>Location</div> <div>ST263</div> <div>44832</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3810-1 Hand Retractable Spring Plunger		Manufactured	No			100	Each	12.0000	1	1		6/11/07/12	
<div> <div>Location</div> <div>ST084</div> <div>57319</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS21209C0815 Heli Coil, screw locking, red		Purchased	No			100	Each	0.0000	4	4		6/11/07/12	
MS21209C6-10 Heli Coil, screw locking, red		Purchased	No			100	Each	22.0000	1	1		6/11/07/12	
<div> <div>Location</div> <div>ST304</div> <div>108847</div> </div> <div> <div>Loc Qty</div> <div>22</div> <div>22</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

M118159 (W)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

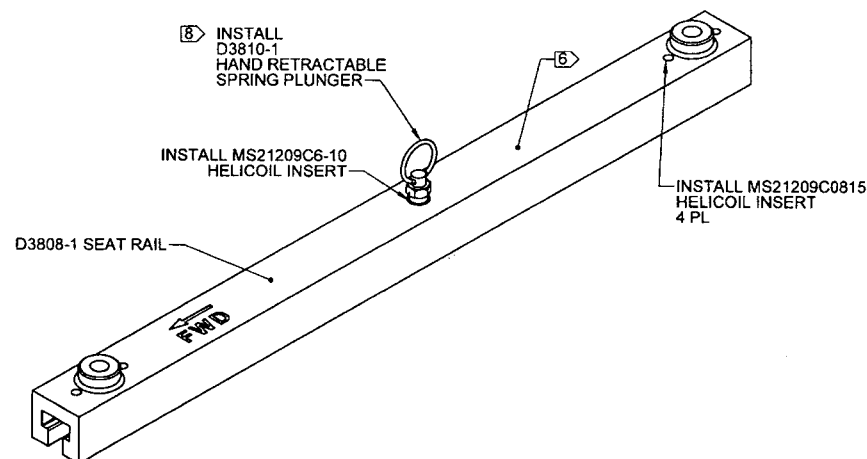
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QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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08-09-30 1/17

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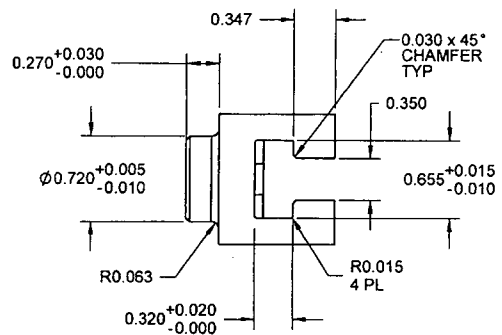
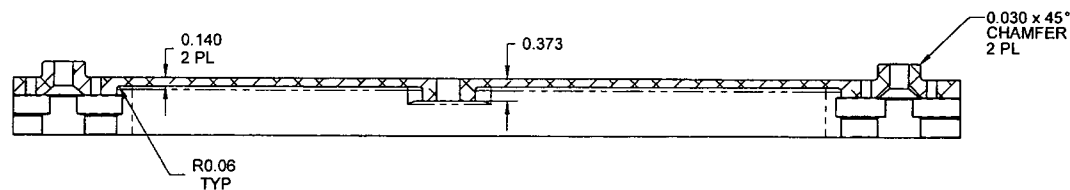
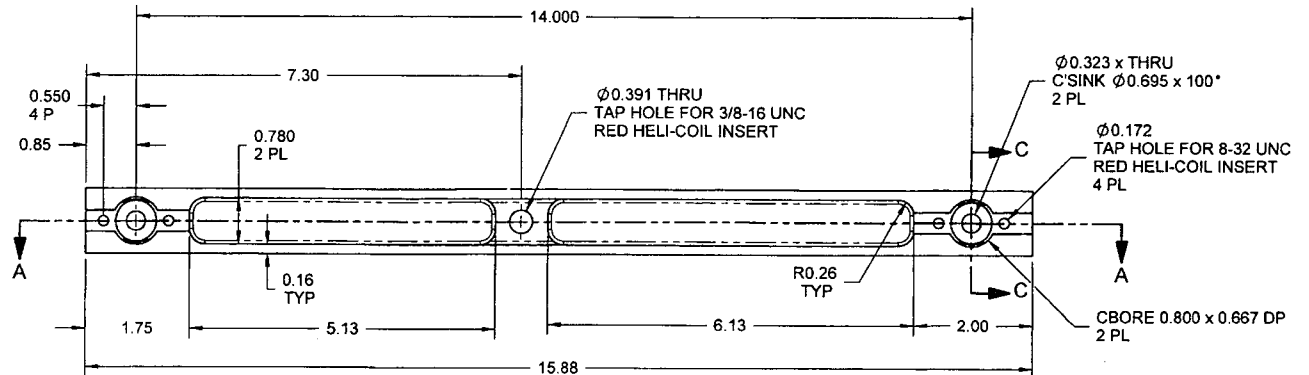
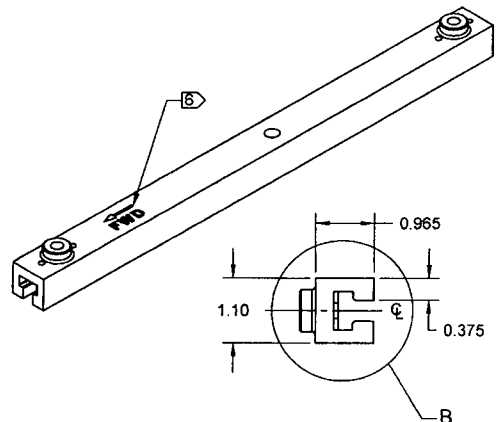
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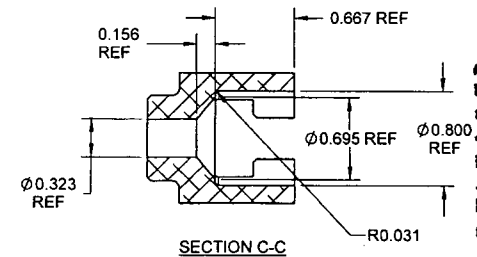
NOTE: Date & initial all entries



DETAIL VIEW B

SECTION A-A

D3808-1 SEAT RAIL



SECTION C-C

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

71146

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3808	REV. A
MFG. APPR.		SHEET 2 OF 2	
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